

Work Order ID: 53194

October 26, 2009 11:39:08 AM



Page 1

Item ID: D3186-1M
Revision ID: E
Item Name: SPACEPOD DOOR LH

Accept



Setup Start



Stop



Start Date: 10/26/09 Start Qty: 1.00
Required Date: 11/04/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *CL*
QC:

Date: *09/10/26* Tooling:
Date: SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3186	Rev E

100 PURCHASING 0.00



Purchasing

Memo 0.00

Purchasing

Issue P/O: *10640* Description: D3186-1M Door Supplier: Delastek
Conformity Certificate and Process sheet required

CL 09/10/26 (1)

110 Receive & Inspect for Damage & Mat'l Certs 0.00



Packaging

Memo 0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Pack 3/19 (1)

120 QC6- Inspect dimensions to drawing 0.00



QC

Memo 0.00

Quality Control

Check for void spot and pins. Ensure surface of doo is smooth, no dimples for drilling.

S. dos/15

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

& initial all entries

Work Order ID 53194

October 26, 2009 11:39:08 AM



Page 2

Item ID: D3186-1M

Accept



Setup Start



Revision ID: E

Stop



Item Name: SPACEPOD DOOR LH

Start Date: 10/26/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/04/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: computer

0.00



Packaging

Memo

0.00

Packaging

85 10.05-18

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/19
Mr
10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 26, 2009 11:39:08 AM

Page 1

Work Order ID: 53194

Parent Item: D3186-1MRevE

Parent Item Name: SPACEPOD DOOR LH




Comments:

Start Date: 10/26/09

Required Date: 11/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-1MRevE  Spacepod Door		Purchased	No			100	Each	0.0000	1.0000 			B53194 

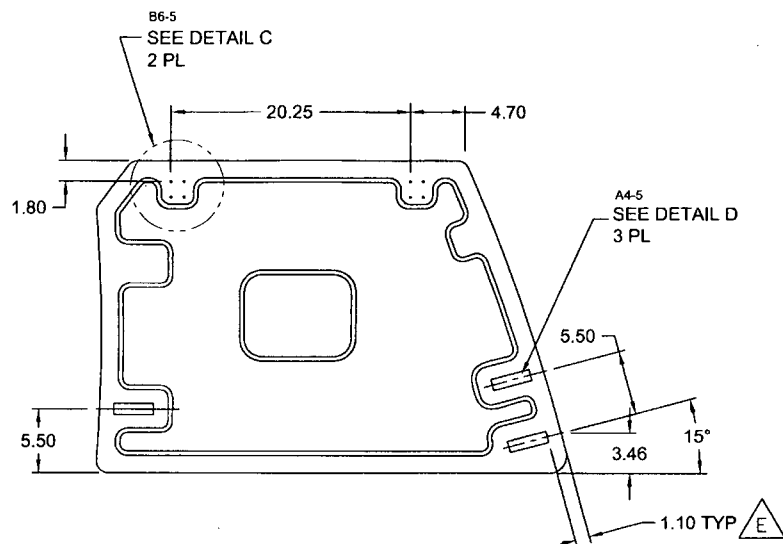
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

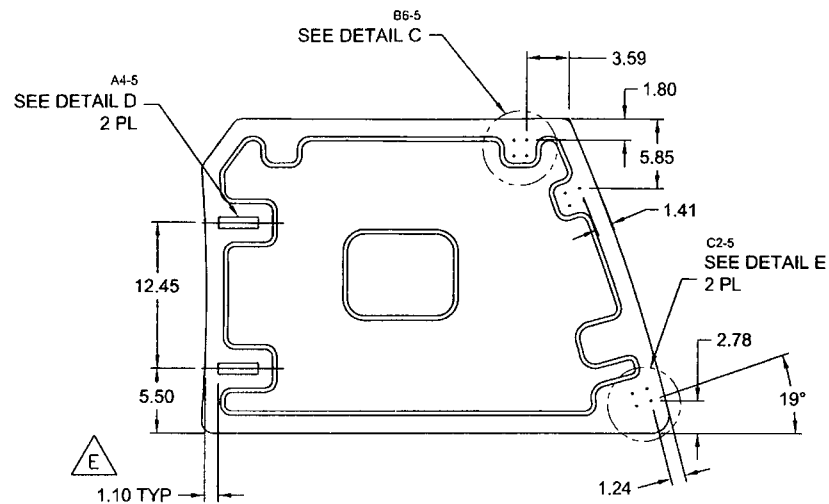
NOTE: Date & initial all entries



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

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2009-09-09

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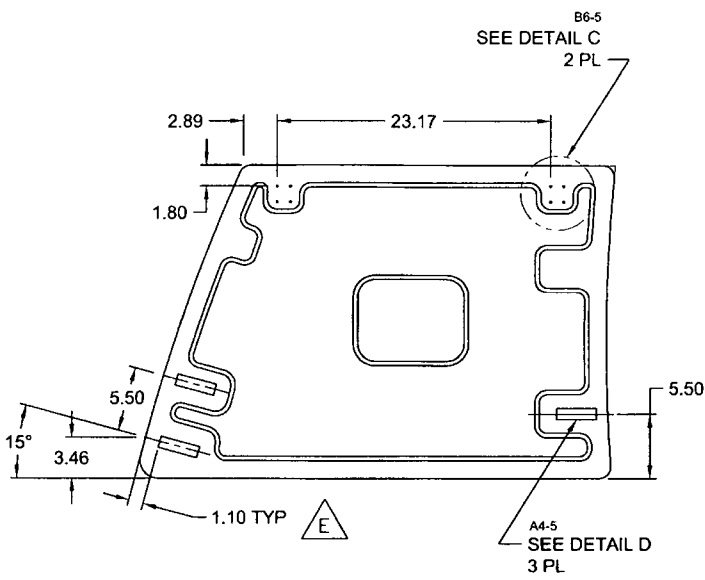
NO. 53194
020911024

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IP	DRAWING NO.	REV. E
MFG. APPR.	ND	D3186	SHEET 1 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	TH	SPACEPOD DOOR	NTS
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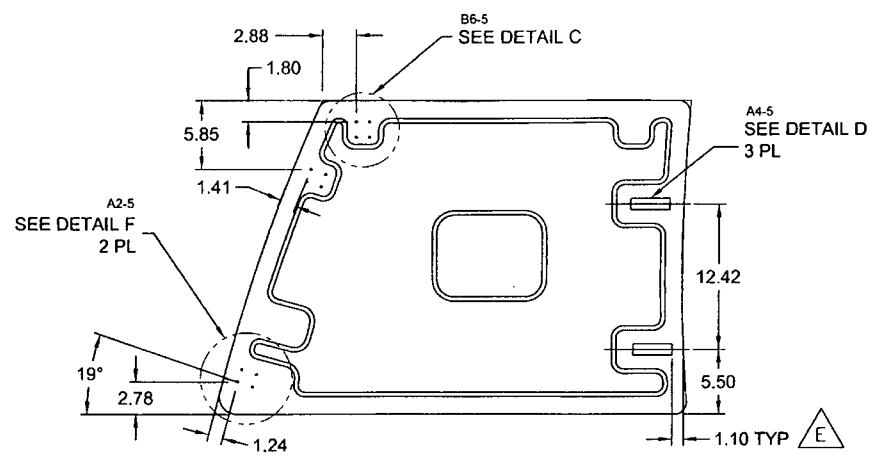
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

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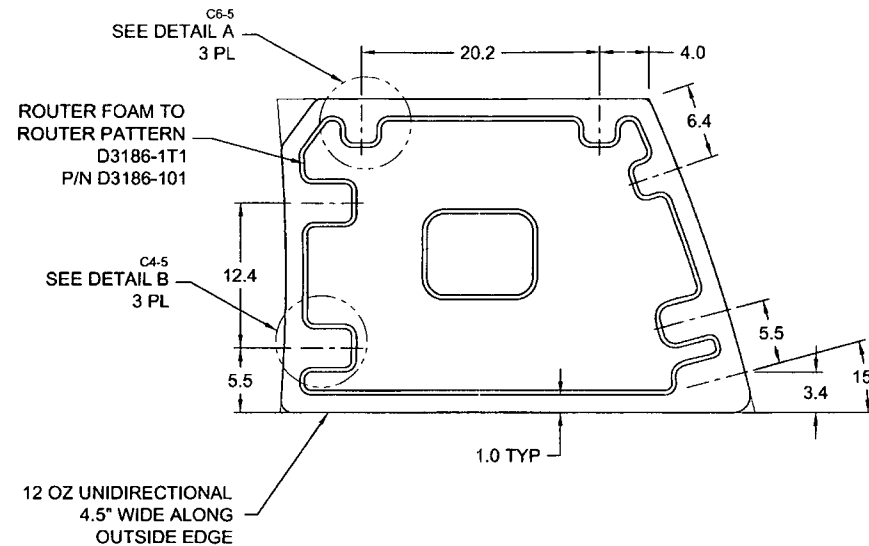
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8 7 6 5 4 3 2 1

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX




6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

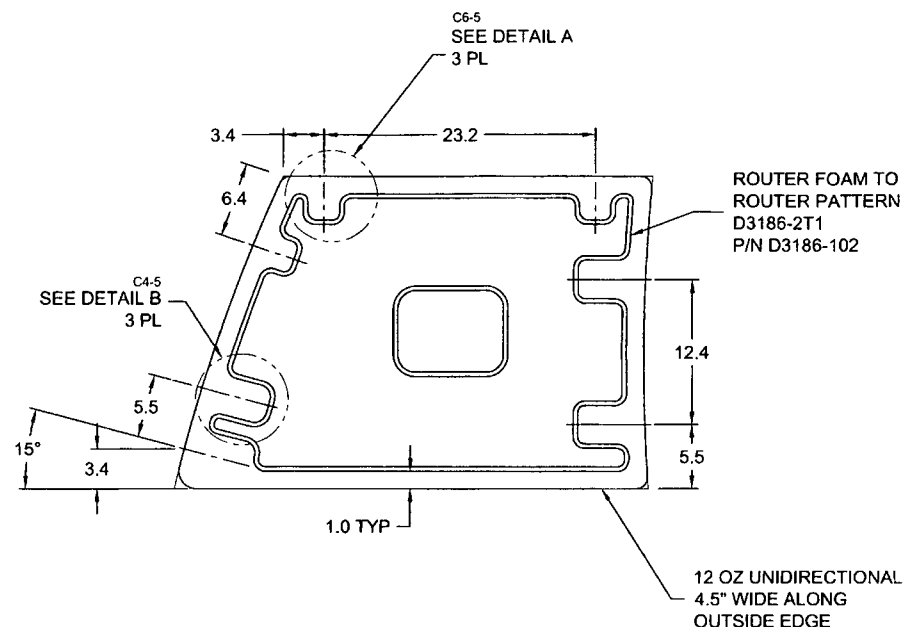
8) USE MOLD DT8005 FOR DOOR LAYUP

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 NO. 23194

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MFG. APPR.		D3186	SHEET 3 OF 5
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9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



1) MATERIAL:

- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 7.0 lbs
8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

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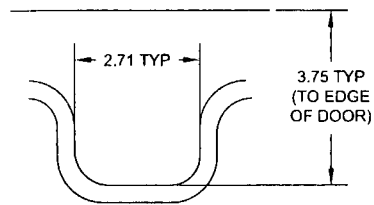
~~WATERGATE~~

WORK ORDER⁴

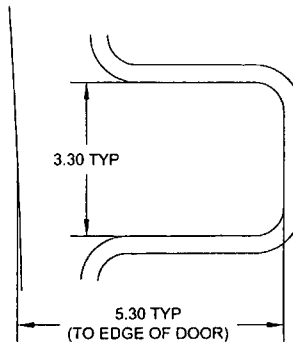
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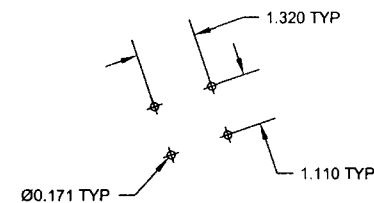
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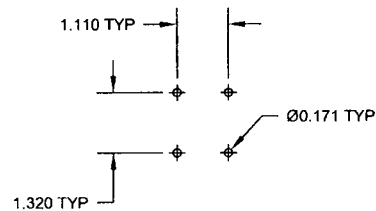
DETAIL A D6-3
SCALE 4X D4-4



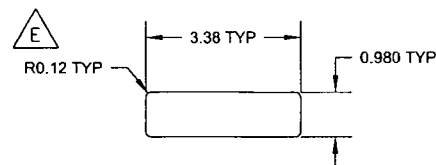
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

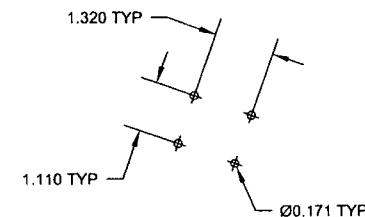


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR




DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

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2009-09-09

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MFG. APPR.		D3186	SHEET 5 OF 5
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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SL CERTIFICATE OF COMPLIAN

Invoice #	13326
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
18/03/2010	26/10/2009	6049	Chantal Lavoie	PO10640 REVISED			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0058	LINE #13 D31861P Spacepod Door LH B53194 Dwg. Rév.: E			
				No. lot 24621			
				10/05/10			
1	0	1	DKC134-0070	LINE #16 D31881P, Spacepod Body LH B53070 Dwg. Rév.: F			
				No. lot 24019			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Vendredi, 2010-02-26 08:48:50
Utilisateur: Mélanie Godin

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD DOOR LH
Numéro Job	: 24621	Numéro Article	: DKC134-0058
Numéro Soumission	: 3411	Numéro Dessin	: D3186
Numéro B.A.	:	Projet Numéro	: DK-359
Cette fois	: 2010-02-26 No. B.V. :	Révision dessin	: E
Prsht Rev.	: NC	Matériel	: 7781 & 411-350
Prem. fois	: - - Type :	Date Dûe	: 2010-03-05 Qté: 1 Udm: UNITE
Job précédente	: 24032		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D31861M		

Process Sheet Rév.: 01 rev. passe à E, corriger qté du AMB0214
était 43.5 verges, ajout AAC1390 et AAC1617, ajout des opérations
de sablage et réparation ainsi qu'une 2ieme étape de primer après
la 1ere étape de primer.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8005 selon IG 0009

Date: / Sceau: /

3.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)

4.0 AC0884 Wrighton 5200 Bleu P3

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26083-1

Date: Vendredi, 2010-02-26 08:48:50

Utilisateur: Mélanie Godin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR LH

Numéro Job: 24621

Numéro Article: DKC134-0058

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)

9.0	AMB0349	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentair Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

10.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 26-02-10 Sceau:



11.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	-----------------------------------------

Commentair Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-26643-1

13.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 26-02-10 Sceau:



14.0	LAMINAGE	Faire le laminage
------	----------	-------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 26-02-10 Sceau:



Date: Vendredi, 2010-02-26 08:48:51
Utilisateur: Mélanie Godin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24621

Nom Dessin: SPACEPOD DOOR LH
Numéro Article: DKC134-0058

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

15.0	BAGGING	Faire le bagging sur la pièce
------	---------	-------------------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 12:35 Heure Fin Curing: 8:00

Date: 26-02-10 Sceau:



16.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

17.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	-----------------------------------------

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-26643-1

18.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core

Date: 1-3-10 Sceau:



19.0	DKC134-0056	Foam Core N° D3186-101 (Porte D3186-1)
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D3186-101 (Porte D3186-1) N° de Job: 44038

20.0	AAC1611	Polybond B46F
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Commentair Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s)
Polybond B46F N° de Lot: 1-25391-1

21.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Date: Vendredi, 2010-02-26 08:48:51
Utilisateur: Mélanie Godin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24621

Nom Dessin: SPACEPOD DOOR LH
Numéro Article: DKC134-0058

Numéro Job:



Séq.: Machine ou Opération: Description :

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 1-3-10 Sceau:



22.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 2 heures minimum

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 1:10

Heure Fin Curing: 2:30

Date: 1-3-10 sceau:



23.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0400 GALLON(s)/Unit Total: 0.0400 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 LITRE(s)/Unit Total: 1.000 LITRE(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-26643-1

25.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 2-3-10 Sceau:



26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 2-3-10 Sceau:



Date: Vendredi, 2010-02-26 08:48:51

Utilisateur: Mélanie Godin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR LH

Numéro Job: 24621

Numéro Article: DKC134-0058

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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27.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 8:10

Heure Fin Curing: 9:50

Date: 2-3-10 sceau:



28.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges selon IG 0018.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 02-03-10 Sceau:



29.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 2/03/10 Sceau:



2/03/10



30.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-26006-1

31.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-26804-2

32.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008

Date: 12/03/10 Sceau:



Date: Vendredi, 2010-02-26 08:48:51

Utilisateur: Mélanie Godin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR LH

Numéro Job: 24621

Numéro Article: DKC134-0058

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: _____ Sceau: _____

Date: _____ Sceau: _____

Date: _____ Sceau: _____

33.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.020 KIT(s)/Unit Total : 0.020 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

de Lot: 1-7129-1

34.0 AAC1617 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

de Lot: _____

35.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du sikkens.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Heure début Curing: _____ Heure Fin Curing: _____

Date: 16-3-10 Sceau:

36.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)

Dupont Primer N° 7704S

de Lot: 1-26006-1

37.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

de Lot: 1-26575-5

38.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer une couche de primer selon IG 0008

Date: 15/03/10 Sceau:

Date: 16-03-10 Sceau: M.A.

Date: 17-03-10 Sceau: M.A.

Date: _____ Sceau: _____

Date: Vendredi, 2010-02-26 08:48:51

Utilisateur: Mélanie Godin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR LH

Numéro Job: 24621

Numéro Article: DKC134-0058

Numéro Job:



Séq.:

Machine ou Opération:

Description :

39.0


INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'inspection finale par la qualité selon le dessin.

Date: 18-3-10 Sceau: 

40.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 18-03-10 Sceau: 